

Date: Monday, 12/01/2009 8:06:08 AM
 User: Chantal Lavoie

Process Sheet

Split for NCR
209-018

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUSHION
 Job Number : 44544 -1
 Estimate Number : 13646
 P.O. Number : Part Number : D3756041
 This Issue : 12/01/2009 S.O. No. : Drawing Number : D3756 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 43543 Material :
 Written By : Due Date : 30/01/2009 Qty: 5 Um: Each
 Checked & Approved By : *C209/01/12*
 Comment : Est: A 08.11.17 New issue EC verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *7942**C209/01/12*

Manufacture D3754-1as per Dwg D3754

(5)

Material: Airflex fire-resistant aircraft cushioning, grade 30-40

layers to be laminated with silaprene DC12906 spray grade HPL contact adhesive

Possible Supplier: Chestnut Ridgefoam

Material release note is required

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

*D3754-1**209/01/20 (5)*

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

209/02/02 (AS)

4.0 D38001200 Hook and Loop Strip (2" Soft)



Comment: Qty.: 0.5250 f(s)/Unit Total : 2.6250 f(s)

Hook and Loop Strip (2" Soft)

Measured

Cut strip 6.00" long ***QTY 2***

Batch: *43559**9/2/13**SC*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 8:06:08 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION

Job Number: 44544

Part Number: D3756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D38001100

Hook and Loop Strip (1" Soft)



Comment: Qty.: 2.6250 f(s)/Unit Total : 13.1250 f(s)

Hook and Loop Strip (1" Soft)

Cut strip 30.00" long

Batch: 43558

measured
5
2/2/3

SP

6.0

D38003100

Hook and Loop Strip (1" Hard)



Comment: Qty.: 2.6250 f(s)/Unit Total : 13.1250 f(s)

Hook and Loop Strip (1" Hard)

Cut strip 30.00" long

Batch: 443560

measured
5
2/2/3

9/2/3

SP

7.0

PG

PURCHASING



Comment: Issue P/O: 8116

Upholster as per Dwg D3756

Supplier: Lefebvre uphol

Ship: -Qty 1 D3754-1 back cushion

-Qty 2 D3800-1-200-060 Loop strip

-Qty 1 D3800-1-100-300, Loop strip

-Qty 1 D3800-100-300, Loop strip

Material release note is required

C209/02/03

(5)

D3756041 P

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

P209/1/13
JAN. 19/06

(P70)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Store

209/03/02 4

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02 7A

Job Completion



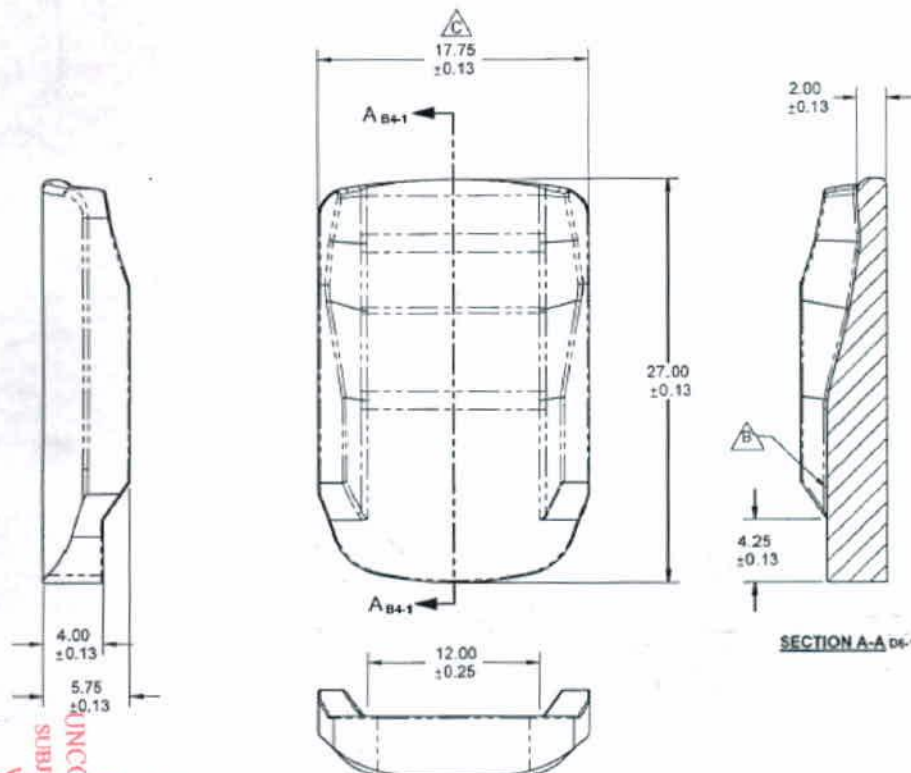
MF 09-03-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3756-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 09/03/04
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44544</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09-02-18</u>	<u>7.0</u>	<u>1 seat is missing the 6" velcro stitched to the back of the seat, as per dwg. D3756-041</u> <u>R.C. Sent sample by mistake Supplier. see attached e-mail.</u>	<u>[Signature]</u> <u>05/04/2</u>	<u>- Split wro, and return the 1 seat back to the contractor to stitch on the velcro strips.</u> <u>- Have them submit a written root cause, and corrective action report.</u> <u>See attached.</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>[Signature]</u> <u>05/04/2</u>	<u>[Signature]</u> <u>09-02-18</u>

NOTE: Date & initial all entries



D3754-1 BACK FOAM

NOTES

- 1) MATERIAL: AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING, GRADE 30-40 (COLOR: LIGHT GREEN) LAYERS LAMINATED WITH SILAPRENE DC12905 SPRAY GRADE HPL CONTACT ADHESIVE SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 603150-99
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3754-1" USING PERMANENT INK MARKER
- 7) WEIGHT: 2.5 lbs
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9028

RELEASED
08/11/05

REV.	DESCRIPTION	BY	DATE
C	CHG DIMS PER CHESTNUT SAMPLE: 17.75 WAS 18.00 (D6-1)	CP	08.10.08
B	REMOVE "HUMP" IN LOWER PART OF FWD (CONCAVE) SIDE (C5-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3754 TITLE BACK FOAM COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	
DRAWN	DP		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	DP		
DE APPR.	DP	BACK FOAM SCALE NTS	
DATE	08.10.08		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

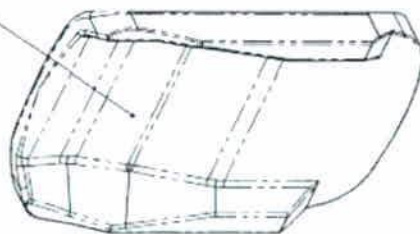
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-1	D3756-041	CUSHION
2	1	X	D3756-1	COVER
3	1		D3754-1	BACK FOAM
4		2	D3800-1-200-000	LOOP STRIP
5		1	D3800-1-100-300	LOOP STRIP (CUT/FIT AS REQ'D)
6		1	D3800-3-100-300	HOOK STRIP (CUT/FIT AS REQ'D)
7		A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY, MORBERN INC. P/N SY-111
8		A/R	THREAD	BONDED POLYESTER 14/2 B BREAK STRENGTH GREY COLOR

COVER SHOULD BE TIGHT TO
FOAM IN CONCAVE AREA SHOWN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44544

D3756-041 CUSHION

RELEASED
10/10/20

- NOTES:
- 1) MATERIAL N/A
 - 2) FINISH NONE
 - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3756-041" USING LABEL
 - 7) WEIGHT: 4.5 lbs
 - 8) SEW D3756-1 COVER TO FIT D3754-1 FOAM
 - 9) STITCH D3800-1-100-300 LOOP AND D3800-3-100-300 HOOK STRIPS ALONG EDGE OF SEAM TO CLOSE COVER.
 - 10) INSTALL THE HOOK STRIP ON THE TOP OVERLAPPING FLAP. INSTALL THE LOOP STRIP ON FABRIC NEXT TO FOAM
 - 11) STITCHING 4-6 STITCHES PER INCH. USE MIN 1/2" BACKSTITCH. NO LOOSE THREADS
 - 12) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT8420

B	COVER NOW CLOSED WITH SINGLE SEAM (2N AS 1 R8-21) D3800-1-100-300 WAS D3800-1-100-665 (D6-11 D3800-2-100-300 WAS D0000-3-100-665 (C-8-1) ADD ITEM NUMBER 85 TO PART LIST (08-11) 1775 WAS 18 00 (04-2)	CP	08 10 21
A	NEW ISSUE	CP	08 09 09
REV	DESCRIPTION	BY	DATE
DESIGN	00		
DRAWN	00		
CHECKED	00		
MFG APPR	00		
APPROVED	00		
DE APPR	00		
DATE	08 10 21		

DART AEROSPACE LTD
HAMMERSBURY ONTARIO CANADA
DRAWING NO
D3756
SHEET 1 OF 2
TITLE
CUSHION
SCALE
N/A
DATE
08 10 21

COPYRIGHT © 2008 BY DART AEROSPACE LTD
ALL RIGHTS RESERVED
NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD

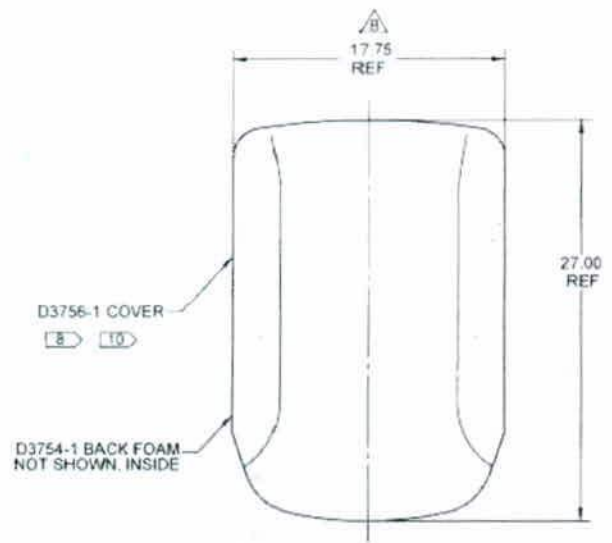
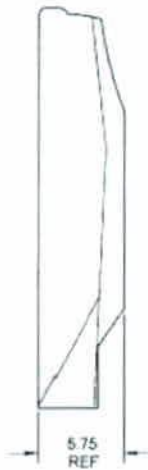
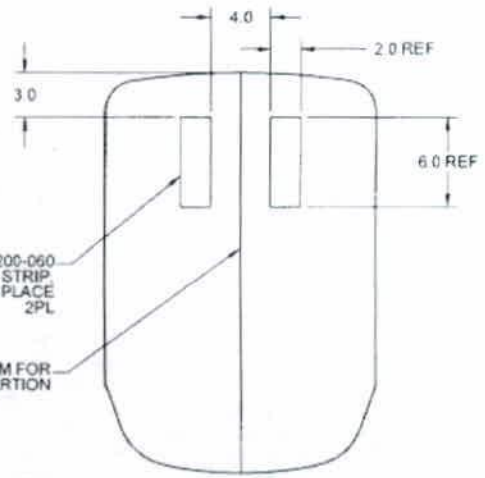
8 7 6 5 4 3 2

D

C

B

A



D3756-041 CUSHION

RELEASED
20/11/05/20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44544

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO	REV. B
MFG. APPR.	GP	D3756	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR	GP	CUSHION	NTS
DATE	08.10.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
<small>THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ISSUED AND NOT FOR ANY OTHER PURPOSE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>			

8 7 6 5 4 3 2 1



Chestnut Ridge
Foam, Inc.

CERTIFICATE OF CONFORMANCE

SOLD TO:
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA

K6A1K7

PURCHASE ORDER: PO00007942
SALES ORDER: 34079
DATE SHIPPED: 01/28/09

**"URGENT! FLAMMABILITY CERTIFICATION
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"**

**I certify that the individual components comprising the part shipped
against the above-referenced purchase order meets the following
requirements:**

14 CFR 25.853(a), APPENDIX F, PART (a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	Part Number	Material	Batch Number
5	D3753-1	503330-99	AIRFLEX40-50	AF9003
			AIRFLEX55-65	AF8056
5	D3754-1	603150-99	AIRFLEX30-40	AF9001

MADE IN THE U.S.A.

S. orlando

Mark A. Brown

Mark A. Brown
Technical Director

CHESTNUT RIDGE FC AM INC.
VERTICAL BURN TEST # 11392
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX
BATCH / LOT NO : AF9001
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 30-40

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

FLAME TEMPERATURE : 1558°F

CONDITIONING STARTED : DATE : 1-8-09
TIME : 9:00 AM

TEST STARTED : DATE : 1-12-09
TIME : 10:10 AM

RESULTS :

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	7.0
#2.	0.0	0.0	6.9
#3.	0.0	0.0	7.0
AVG.	0.0	0.0	7.0

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : KELLY BURES
SR. LAB TECHNICIAN





LEFEBVRE'S UPHOLSTERY

PO BOX 1965
CORNWALL, ON
K6H 6N7

Invoice

Date	Invoice #
11/02/2009	3410

Bill To
DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7

Ship To
DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7

P.O. No.	Terms	Rep	Ship	Via	F.O.B.
PO00008116	Due on Receipt	LP	11/02/2009	Courier	CORNWALL
Quantity	Item	Description		Price Each	Amount
5	SET	COVERS D3755-041 AS PER SPECS COVERS D3756-041 SURREY VINYL 111 SILVER SUNSET PACKING SLIP: 645348 FEB. 5 - 2009 THREAD BONDED POLYESTER UTILIZED Numéro d'entreprise : 885239855		0.00	0.00T
Subtotal				\$0.00	

Phone #	Fax #	E-mail
613-938-3046	866-449-5408	globaltrends@myibocs.com

Surrey

FROM THE DEFENSE FINISH COLLECTION

Specifications

- Nominal total thickness: .044 ± .045 inches (.44 ± 4.5 mils)
- Standard weight: 30.75 ± 1.5 ounces per linear yard
- Abrasion resistance: No significant wear after 200,000 double rubs with #8 cotton duck using the Wyzenbeek test method
- Anti-Bacterial/Anti-Microbial treatments
- -25° F cold crack resistance
- Anti-static finish
- Sulfide stain resistant
- Oil resistant
- Width: 54 inches
- Roll length: 40 yards

Flame Resistance

Manufactured to meet the following flammability* requirements

- Port Authorities of New York and New Jersey
- CID-A-A-2950-A (Formerly CCC-A-680a)
- Federal Standard 191A Test Method 5903.1
- Federal Specification CCC-A-700J
- FAA Regulation 25.853 (a) and Appendix F, Part 1 (a) (i) (ii)
- NFPA 701-89 and 701-99 Small Scale Test
- FMVSS 302
- California Flammability Regulation (Bulletin 117, Section E)
- BIFMA Class A
- UFAC Class 1

* This term and all corresponding data refer to typical performance in the specific test indicated and should not be construed to imply the behavior of this or any other material under actual fire conditions.

Care and Cleaning Instructions

It is recommended that each stain is cleaned in a stepwise manner using the sequence below.

- Step 1: Regular cleaning (dirt and grime): Use mild soap and water, then fresh water rinse. Cleaning frequency depends on use. As a minimum, please clean weekly.
- Step 2: Stubborn stains (crayon, eye shadow, chocolate, blood): Wipe using a soft cloth or soft brush. Use detergent cleaners such as Formula 409 or Fantastik. Rinse with clean water and wipe dry.
- Step 3:** More difficult stains (ballpoint pen, lipstick, mustard, tar or asphalt): Carefully clean the stained area with lighter fluid or rubbing alcohol. Carefully rinse with clean water and dry. Note: For best results, immediate attention is required for severe stains.

**Caution: Exercise care as these solvents are flammable. Use only small quantities of solvents and keep clear of any sources of ignition. Wear protective gloves and ensure cleaning takes place in a well ventilated area.

MELLOHIDE
Brand

Jason Murdoch

From: L Lacelle [llacelle@dartaero.com]
Sent: February 27, 2009 7:12 AM
To: 'Jason Murdoch'
Cc: 'Mike Petsche'; 'David Shepherd'; 'Susanne Sheldon'; 'Bill Beckett'
Subject: RE:

Perfect, thx Bill

Jason, please remove from quar., also, please proceed with inspection of cushions received. So we can get a few more in stock.

Thx

LL

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: February 26, 2009 3:37 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; 'Susanne Sheldon'; Jason Murdoch
Subject: RE:

Linda,

While flying the Eagle Single #7 to HAI, Mike O felt the seat wasn't quite long enough to support the thigh area completely, but this is somewhat subjective. To address this would take significant re-design efforts and result in a far more costly kit.

After further review at HAI I have decided to continue shipping this product out as is. If we need to make changes to the kit, we will do so after evaluation of more customer feedback. As well, Spyke is doing a week of demo flying in Eagle #7 so we will get more feedback after this.

Thanks,

Bill

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: February 26, 2009 12:47 PM
To: bbeckett@dartaero.com; 'Mike Petsche'
Subject: FW:
Importance: High

Are we still keeping the comfort seats in quar.???

From: Carrie Pearson [mailto:carrie@darths.com]
Sent: February 26, 2009 11:30 AM
To: llacelle@dartaero.com
Cc: Holly Menard
Subject:

Hi Linda,

Could we ship today if we get a PO for:

Qty 1 D205-778-011

What colors do we offer for this?

27/02/2009

Thank you

Carrie Pearson

Sales Associate

DART Helicopter Services, LLC

Tel: 1.613.632.3336

Tol: 1.800.556.4166

Fax: 1.613.632.4443

carrie@darths.com

www.darthelicopterservices.com

"We provide solutions"

Disclaimer - This email and any files transmitted with it are confidential and may contain privileged or copyright information. You must not present this message to another party without gaining permission from the sender. If you are not the intended recipient you must not copy, distribute or use this email or the information contained in it for any purpose other than to notify us.

If you have received this message in error, please notify the sender immediately, and delete this email from your system. We do not guarantee that this material is free from viruses or any other defects although due care has been taken to minimize the risk.

Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

LEFEBVRE'S UPHOLSTERY
P.O. Box 1965
CORNWALL, ON
K6H 6N7

March 3, 2009

To: Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7

From: Lefebvre's Upholstery

None conformance report.

A batch of covered cushion was fabricated and sent to Dart Aerospace on Feb. 26, 2009.

It was noticed once at Dart Aerospace that one back did not have the 2" x 6" velcro sewn on the cover to permit it to attach to tub frame.

I was notified of this and upon investigation. I noticed that my sample cover had been attach to the foam bun which does not have the velcro strips sewn in to the cover. My sample now had the strips of velcro. I had taken my sample by mistake and sent with the batch.

The cover was return to me and the switch made and return the same day,



Pierre Lefebvre
President
LEFEBVRE'S UPHOLSTERY